wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof; and

A1 cont'd

(c) wherein the shrinkage of the biaxially oriented multi-layer film at 135° C is less than 25% in the machine and transverse directions.

6. (once amended) The biaxially oriented multi-layer film of claim 5 comprising a second layer adjacent to the core layer comprising a material selected from the group consisting of butene-1-propylene random copolymer, ethylene-propylene block copolymer, nylon, polyester, ethylene-vinyl acetate copolymer, ethylene-vinyl alcohol copolymer, ethylene-propylene-butene-1 random terpolymer containing 1 to 5 wt.% random ethylene and 10 to 25 wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof.

A2

10. (once amended) A biaxially oriented multi-layer film which comprises:

(a) a core layer comprising a syndiotactic propylene polymer;

(b) a first outer layer adjacent to a first side of the core layer wherein the first outer layer comprises a material selected from the group consisting of butene-1-propylene random copolymer, ethylene-propylene block copolymer, nylon, polyester, ethylene-vinyl acetate copolymer, ethylene-vinyl alcohol copolymer, ethylene-propylene-butene-1 random terpolymer containing 1 to 5 wt.% random ethylene and 10 to 25 wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof;

A3

(c) a second outer layer applied to an outer surface of the first outer layer, wherein the second outer layer comprises a material selected from the group consisting of butene-1-propylene random copolymer, ethylene-propylene block copolymer, nylon, polyester, ethylene-vinyl acetate copolymer,

ethylene-vinyl alcohol copolymer, ethylene-propylene-butene-1 random terpolymer containing 1 to 5 wt.% random ethylene and 10 to 25 wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof;

A3 cont'd

(d) a third outer layer adjacent to a second side of the core layer, wherein the third outer layer comprises a material selected from the group consisting of butene-1-propylene random copolymer, ethylene-propylene block copolymer, nylon, polyester, ethylene-vinyl acetate copolymer, ethylene-vinyl alcohol copolymer, ethylene-propylene-butene-1 random terpolymer containing 1 to 5 wt.% random ethylene and 10 to 25 wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof;

(e) a fourth outer layer applied to an outer surface of the third outer layer, wherein the fourth outer layer comprises a material selected from the group consisting of butene-1-propylene random copolymer, ethylene-propylene block copolymer, nylon, polyester, ethylene-vinyl acetate copolymer, ethylene-vinyl alcohol copolymer, ethylene-propylene-butene-1 random terpolymer containing 1 to 5 wt.% random ethylene and 10 to 25 wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof; and

(f) wherein the shrinkage of the biaxially oriented multi-layer film at 135° C is less than 25% in the machine and transverse directions.

A4

13. (once amended) A process for preparing a biaxially oriented multi-layer film having a shrinkage at 135° C of less than 25% in the machine and transverse directions which comprises the steps of:

A4 cont'd

(a) melt coextruding a film comprising: (i) a core layer comprising at least about 90% of a syndiotactic polypropylene, (ii) a first additional layer adjacent to a first side of the core layer comprising materials selected from the group consisting of butene-1-propylene random copolymer, ethylene-propylene block copolymer, nylon, polyester, ethylene-vinyl acetate copolymer, ethylene-vinyl alcohol copolymer, ethylene-propylene-butene-1 random terpolymer containing 1 to 5 wt.% random ethylene and 10 to 25 wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof, and (iii) a second additional layer adjacent to a second side of the core layer comprising materials selected from the group consisting of butene-1-propylene random copolymer, ethylene-propylene block copolymer, nylon, polyester, ethylene-vinyl acetate copolymer, ethylene-vinyl alcohol copolymer, ethylene-propylene-butene-1 random terpolymer containing 1 to 5 wt.% random ethylene and 10 to 25 wt.% random butene-1, low density polyethylene, linear low density polyethylene, medium density polyethylene, high density polyethylene, polypropylene, and blends thereof, and

(b) biaxially orienting the coextruded combination in a machine and a transverse direction.

16. (new) The film of claim 1 wherein the at least one additional layer adjacent to the core layer is comprised of isotactic polypropylene.

A5

17. (new) The film of claim 6 wherein the second layer adjacent to the core layer is comprised of isotactic polypropylene.

18. (new) The film of claim 10 wherein the first outer layer, the second outer layer, the third outer layer, and the fourth outer layer are comprised of isotactic polypropylene.

As cont'd

19. (new) The process of claim 13 wherein the first additional layer and the second additional layer are comprised of isotactic polypropylene.